

Date: Friday, 9/15/2006 11:58:53 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FRAME WELDMENT
Job Number	: 28614		
Estimate Number	: 11202		
P.O. Number	: N/A	Part Number	: D3330041
This Issue	: 9/15/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3330 REV B1
First Issue	: N/A	Project Number	: N/A
Previous Run	: 28613	Drawing Revision	: B1
		Material	: N/A
		Due Date	: 10/5/2006
Written By	: <u>[Signature]</u>	Qty:	2 Um: Each
Checked & Approved By	: <u>[Signature]</u>		
Comment	: Est. A05.003 New Issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D33301	Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Panel

Pick:

Qty Part Number Description Batch

1	D3330-1	Panel	B22258
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PCL 06.10.30

②

2.0	D33302	Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Panel

Pick:

Qty Part Number Description Batch

1	D3330-2	Panel	B28624
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PCL 06.10.30

②

3.0	D33303	Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Panel

Pick:

Qty Part Number Description Batch

1	D3330-3	Panel	B28625
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PCL 06.10.30

②

4.0	D33305	Rail
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rail

Pick:

Qty Part Number Description Batch

1	D3330-5	Panel	B28626
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PCL 06.10.30

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/15/2006 11:58:53 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRAME WELDMENT

Job Number: 28614

Part Number: D3330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D33307

Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

(2)

Panel

Pick:

Qty Part Number Description Batch
1 D3330-7 Panel B28627

CPL 06.10.30

6.0

D33309

Top Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

(2)

Top Plate

Pick:

Qty Part Number Description Batch
1 D3330-9 Panel B28628

CPL 06.10.30

7.0

D333011

Long Pin Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

(2)

Long Pin Bracket

Pick:

Qty Part Number Description Batch
1 D3330-11 Long Pin Bracket B23590

CPL 06.10.30

8.0

D333013

Short Pin Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

(2)

Short Pin Bracket

Pick:

Qty Part Number Description Batch
1 D3330-13 Short Pin Bracket B23044

CPL 06.10.30

9.0

D333015

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

(2)

Handle

Pick:

Qty Part Number Description Batch
1 D3330-15 Handle B28623

CPL 06.10.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/15/2006 11:58:53 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRAME WELDMENT

Job Number: 28614

Part Number: D3330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D333017

Handle Socket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle Socket

Pick:

Qty Part Number Description Batch
1 D3330-17 Handle Socket B23047

Cpl 06.10.30

(2)

11.0

D333019

Handle Rim



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle Rim

Pick:

Qty Part Number Description Batch
1 D3330-19 Handle Rim B23048

Cpl 06.10.30

(2)

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble and Weld as per Dwg Dwg D3330 using D3330-041T1

Identify as D3330-041

Cpl 06.10.31 (2)

13.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

06/10/01 (2)

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

06/11/06 (2)

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/11/07 (2)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5707

06/11/07 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 06/11/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/15/2006 11:58:54 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRAME WELDMENT

Job Number: 28614

Part Number: D3330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

Doc 11/107

Job Completion



C Log 11/107

4.3

6.2

1.2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

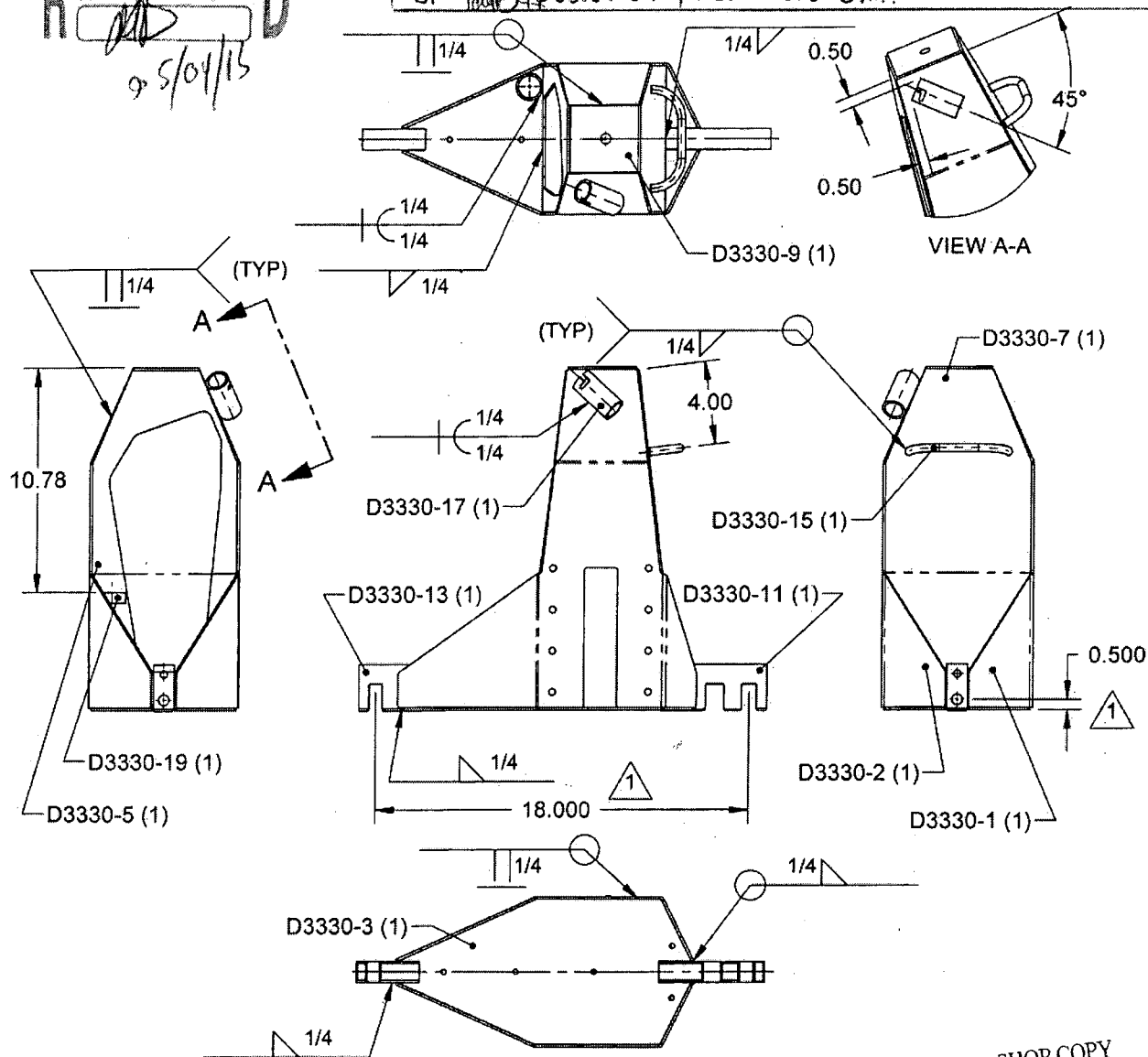
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:8
A	04.12.16	NEW ISSUE	
B	05.02.26	REDESIGN	
BI	05.07.04	ADD 1.605 DIM.	

RELEASED
[Signature]
9/5/04/15**D3330-041 FRAME WELDMENT****NOTES:**

- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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NO. **28614**

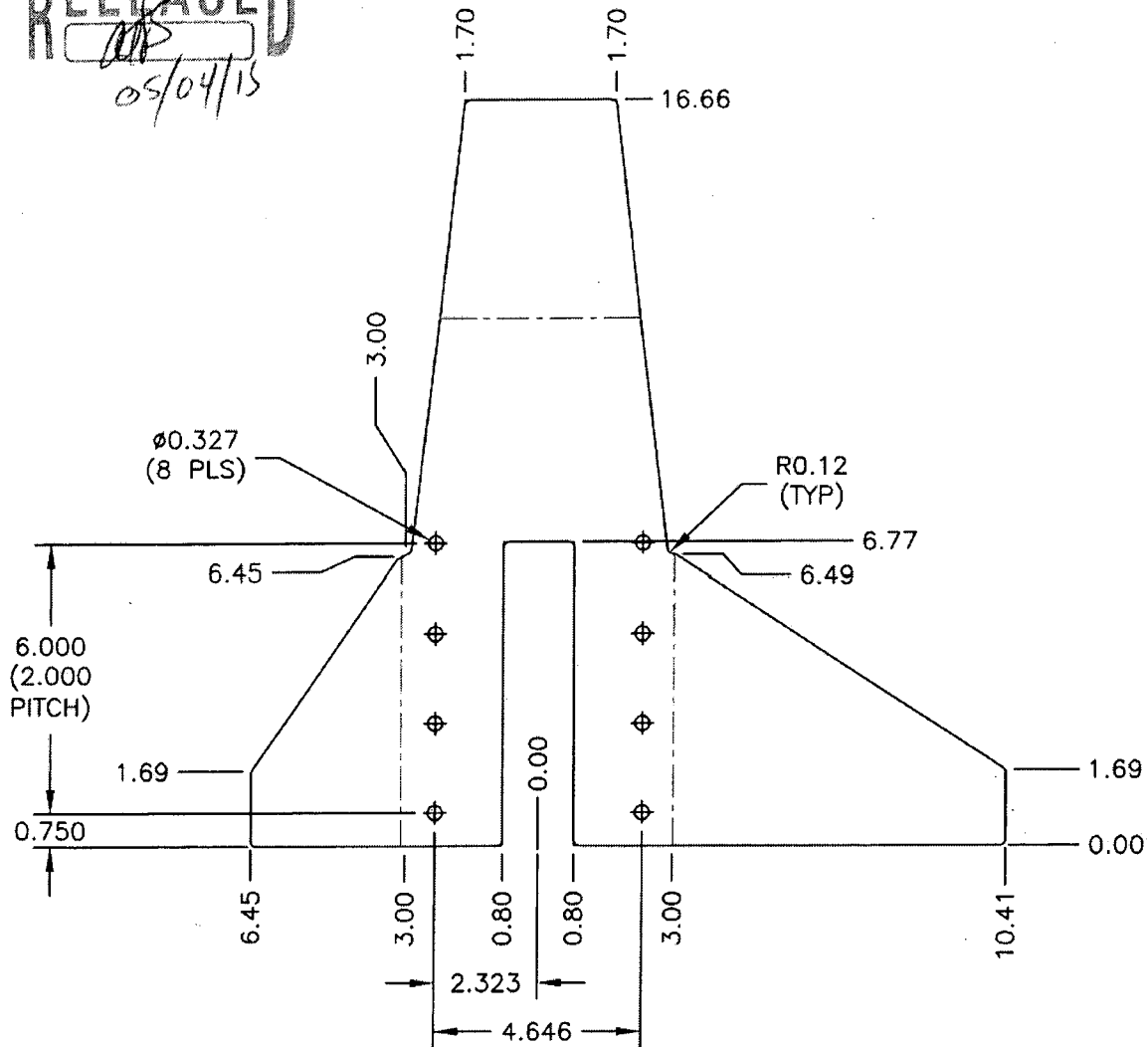
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DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:4

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05/04/15



D3330-1 PANEL

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40.21 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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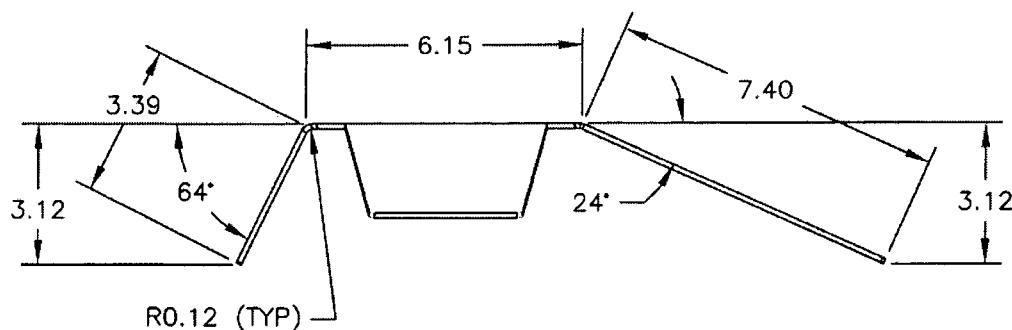
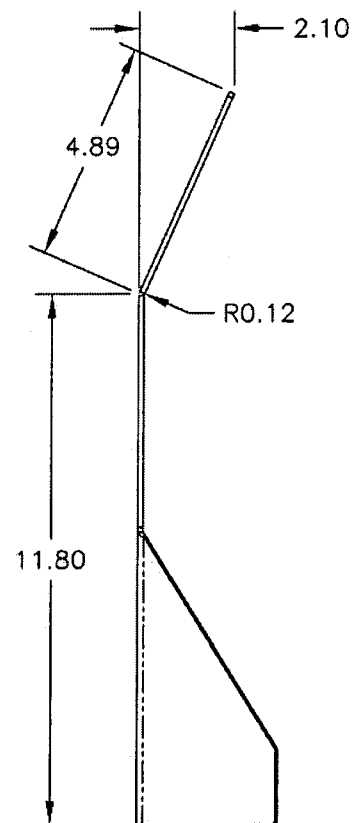
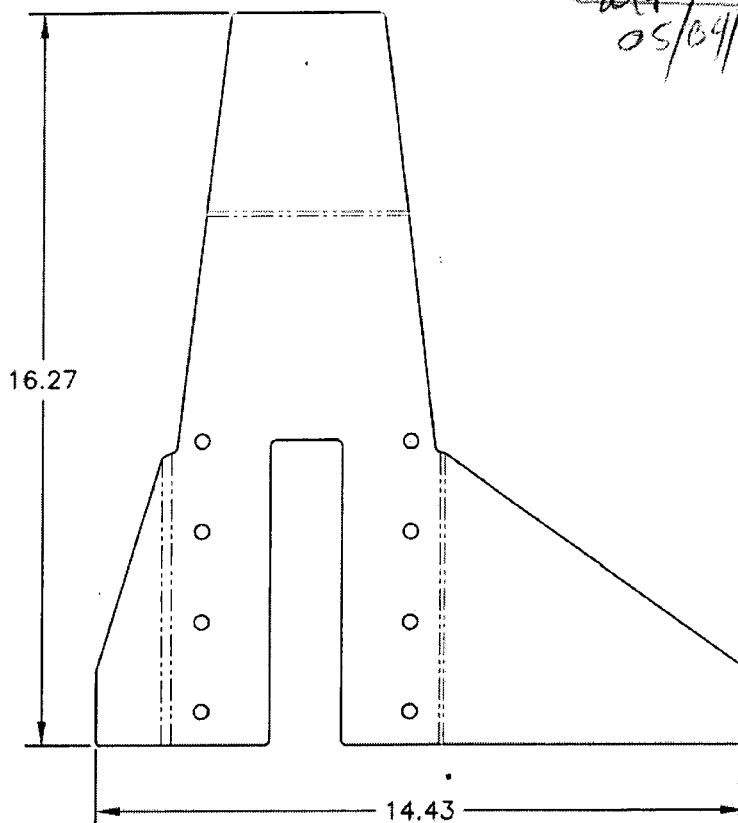
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DATE 05.02.26	TITLE FRAME WELDMENT		SCALE 1:4

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05/04/15

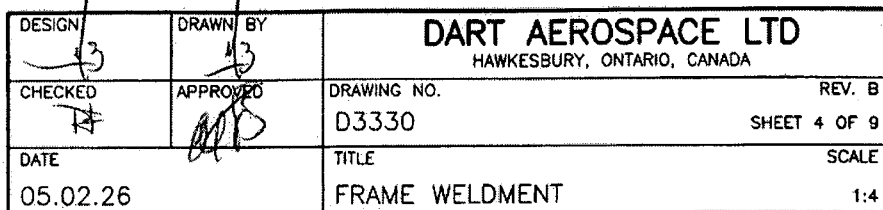


D3330-1 BEND DETAIL (SHOWN)
BEND D3330-2 (OPPOSITE)

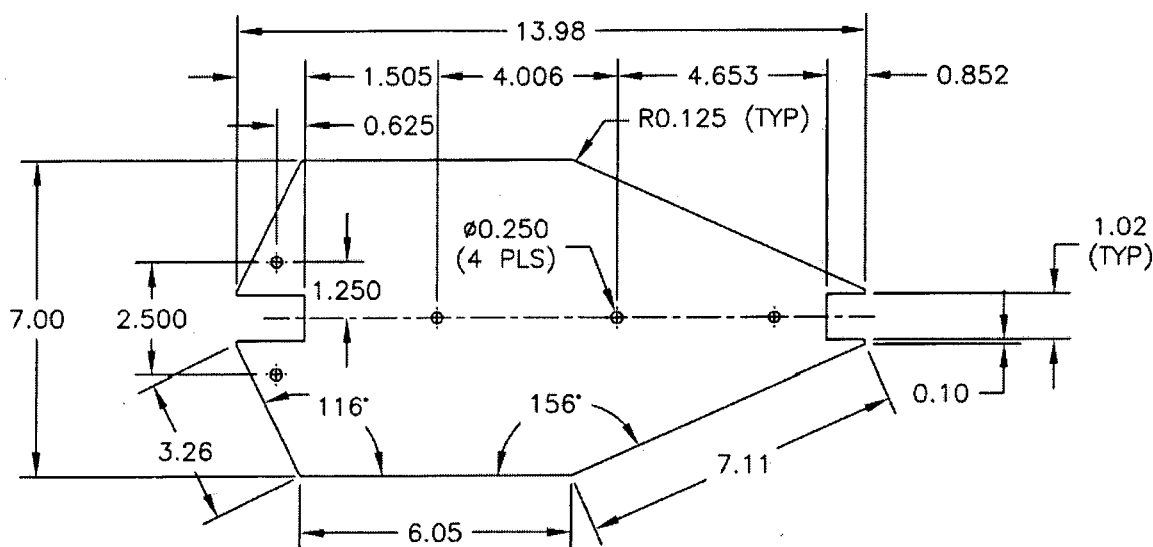
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05/04/13



D3330-3 PLATE

1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21
38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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40-21,
SUBJECT TO AMENDMENT
25 (THICK)

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WORK-ORDER

W5530ND1.1

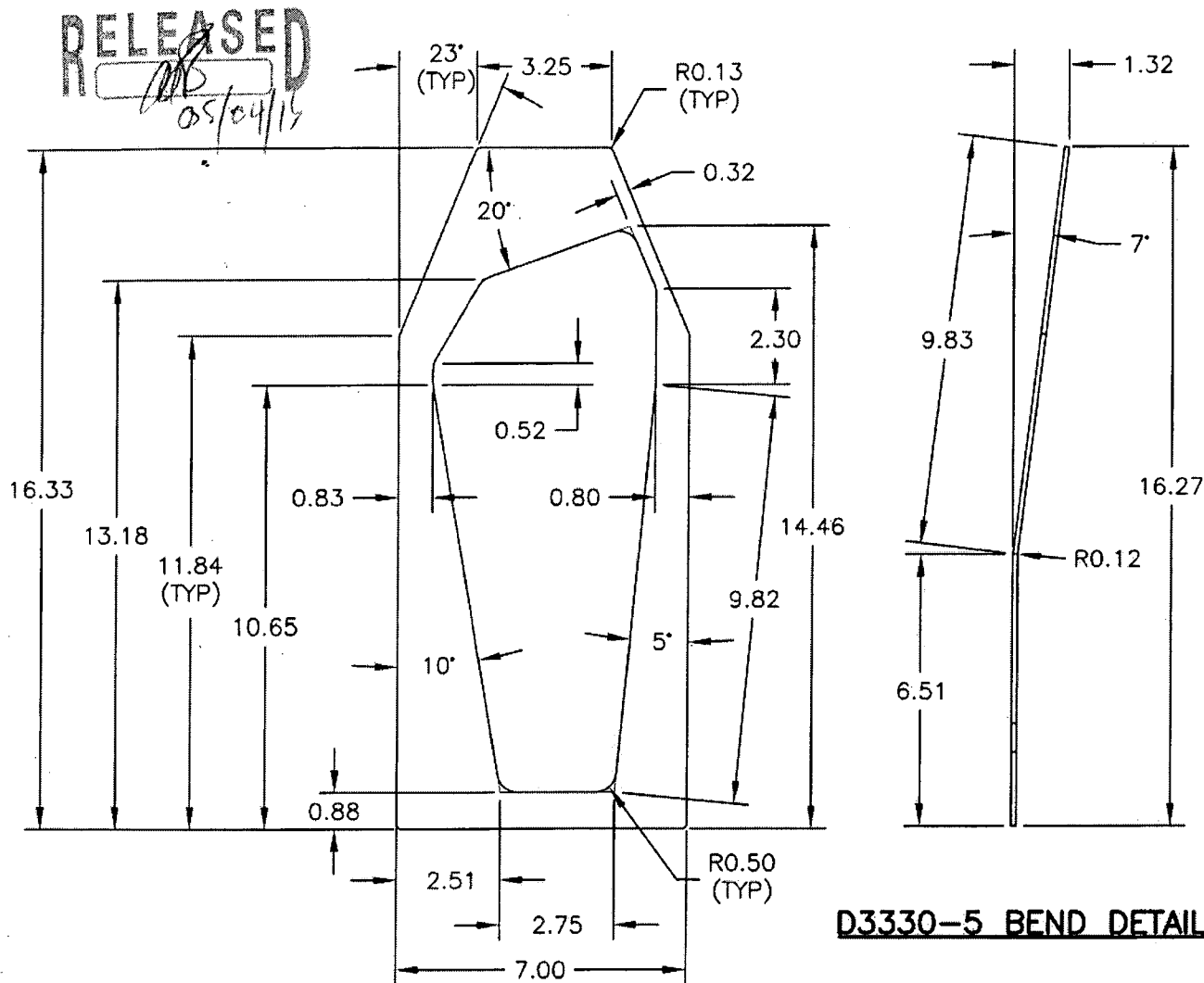
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DATE 05.02.26	TITLE FRAME WELDMENT		SCALE 1:4



FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, RETURN TO 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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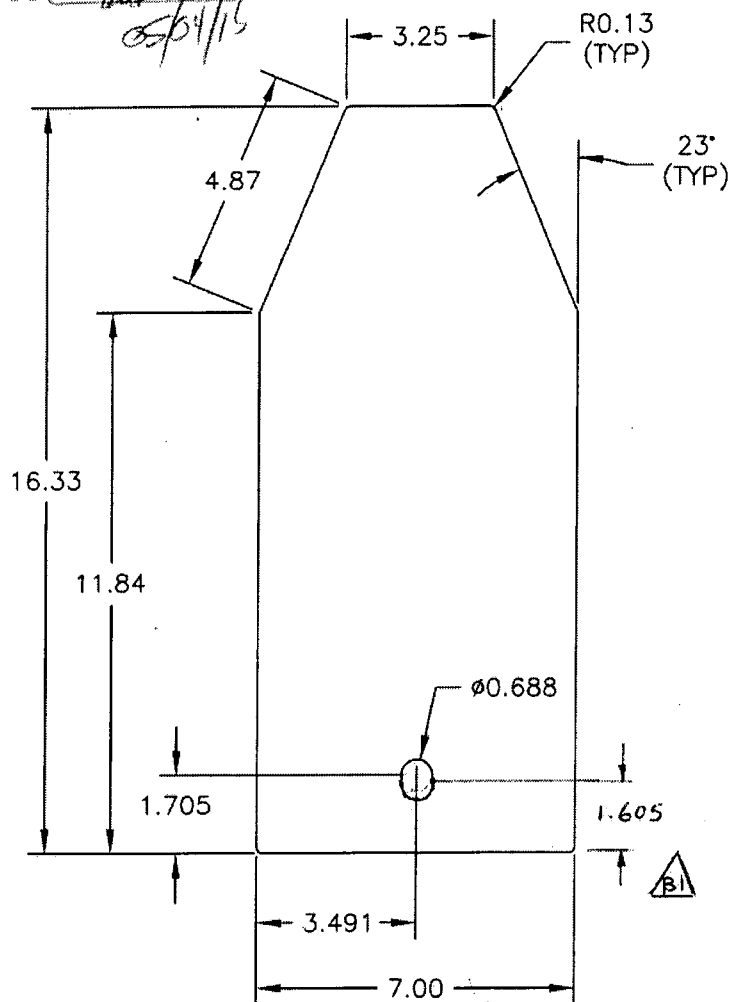
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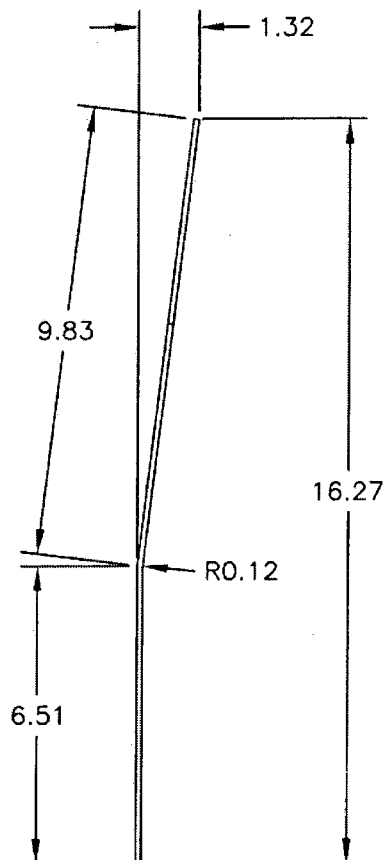


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DATE 05.02.26	TITLE FRAME ASSEMBLY		SCALE 1:4

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[Signature]
05/04/15



FLAT PATTERN



D3330-7 BEND DETAIL

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125" THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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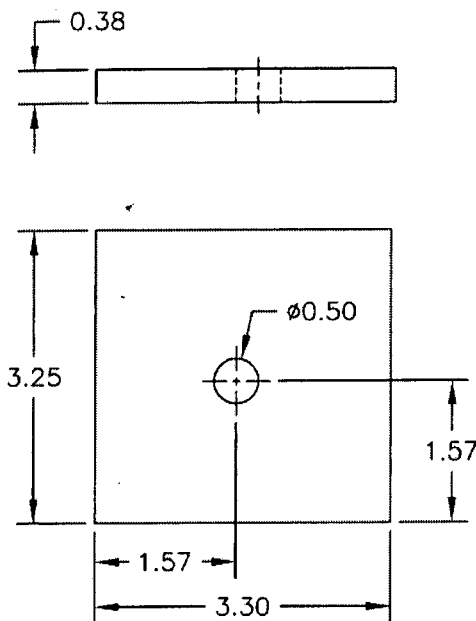
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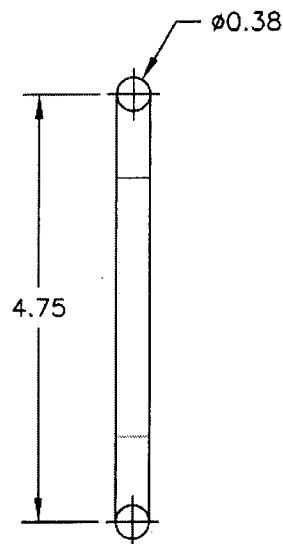
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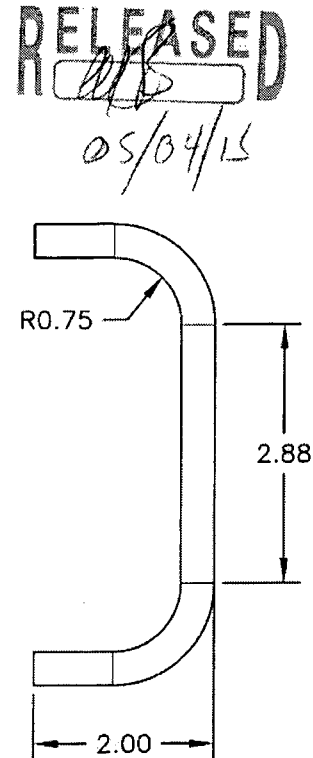
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DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:2



△ D3330-9 TOP PLATE



△ D3330-15 HANDLE



NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008, 0.375 STEEL
(REF. DART SPEC. M1010-B0.375x3.500)
- 2) MATERIAL: AISI 1018-1025 ROUND BAR PER MIL-S-7097
(REF. DART SPEC. M1018-R0.375)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

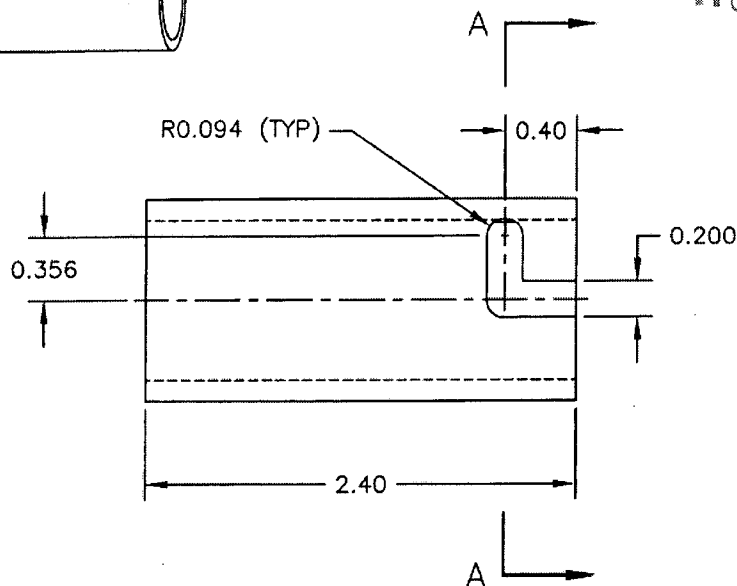
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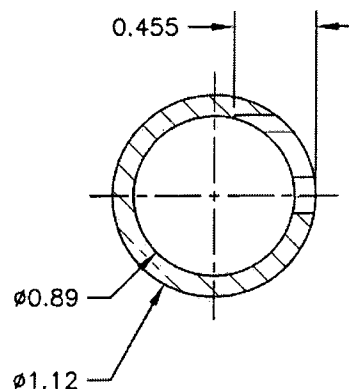
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DATE 05.02.26	TITLE FRAME WELDMENT		SCALE 1:1

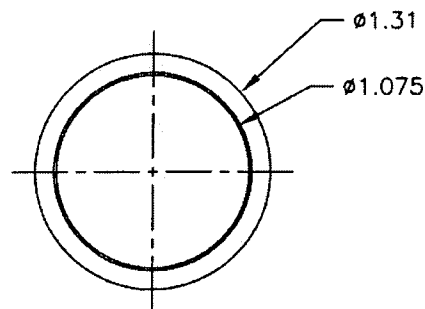
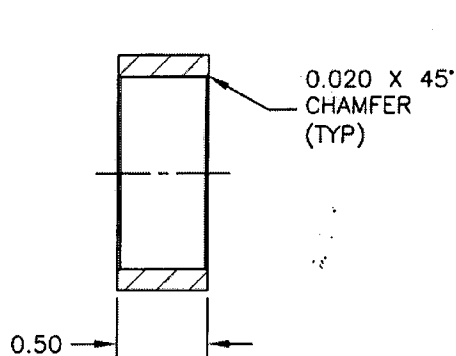


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05/04/15



SECTION A-A

D3330-17 HANDLE SOCKET



D3330-19 HANDLE RIM

NOTES:

- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097 (REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

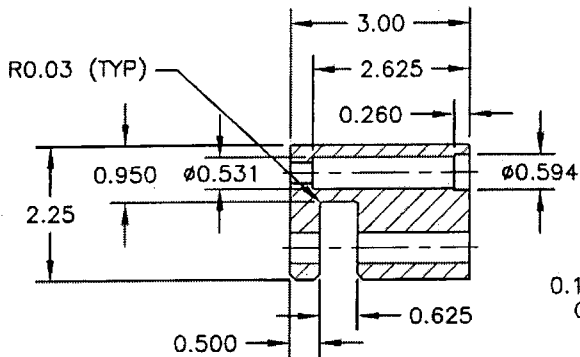
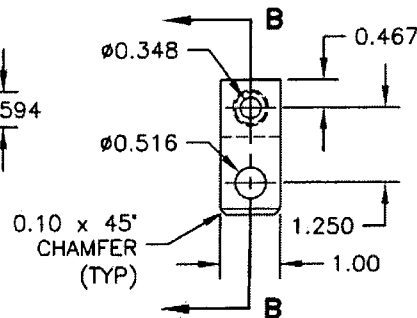
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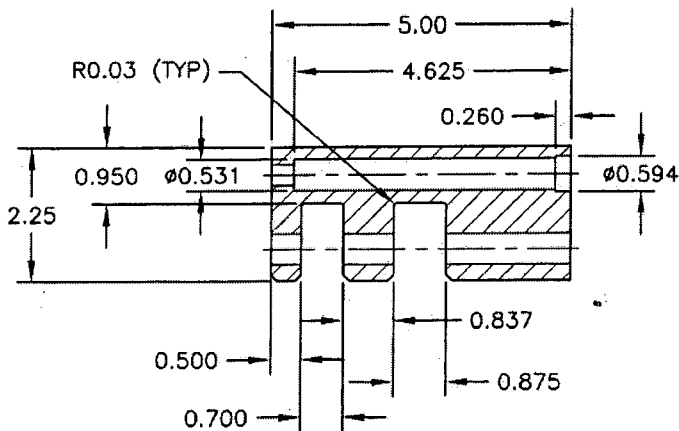
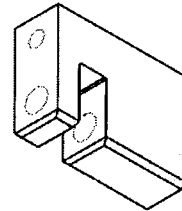
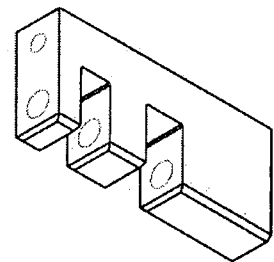
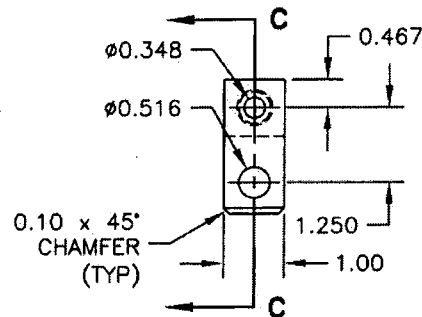
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DATE 05.02.26	TITLE FRAME WELDMENT		SCALE 1:3

**SECTION B-B****D3330-13 SHORT PIN BRACKET**

RELEASED
05/04/15.

**SECTION C-C****D3330-11 LONG PIN BRACKET****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL (REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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